

# Process Sheet

*H. Split*

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 35297-2  
Estimate Number : 12883  
P.O. Number :  
This Issue : 22/10/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : // Type : SMALL /MED FAB  
Previous Run : 35031  
Written By :  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07.05.24 EC  
Est Rev B ECN 987 07.10.09 EC

Drawing Name : ARM

Part Number : D3560043  
Drawing Number : D3560 UNDER REVIEW  
Project Number : N/A  
Drawing Revision : C  
Material :  
Due Date : 29/10/2007

Qty: 14 Um: Each

## Additional Product

Job Number:



## Description :

Seq. #: Machine Or Operation:

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total : 19.0365 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M106182

*OK 07/11/30*

(14)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long

*OK 07/11/30*

(14)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: *AA* & Dwg D3560 Rev: *C*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

*25 07/12/07*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*25 07/12/02*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*25 07/12/11* (14)





# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35297

Part Number: D3560043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)  
PLATE 335331 = 5

08.01.31 5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

## STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad )
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (60°)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

08.01.31 5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.01.31 5

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08.02.04 5

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08.02.04 5

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.02.04 5





Date: Monday, 22/10/2007 2:17:19 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35297

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Spacer

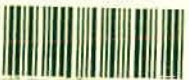
batch: B35330

08/02/04

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

08/02/04 (5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/04 (5) AB

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

08.02.04

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/06 (5)

Job Completion



2008/2/04 (5)

h





## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

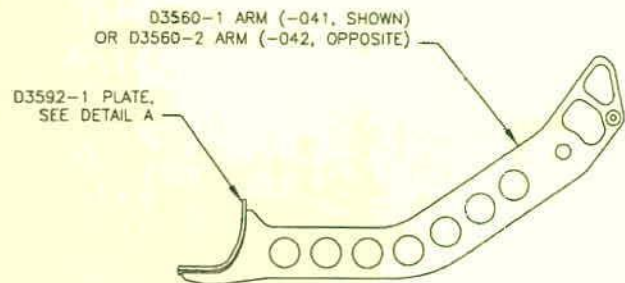
[illegible]

Measured by: <i>8P</i>	Audited by: <i>J.L</i>	Prototype Approval: <i>N/A</i>
Date: <i>07/12/07</i>	Date: <i>07/12/07</i>	Date: <i>N/A</i>
		Revised by: <i>Approved</i>

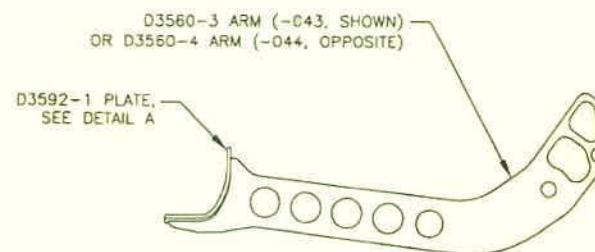
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	



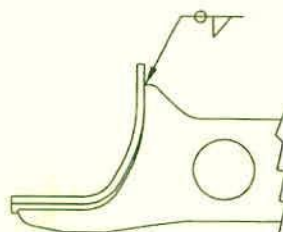
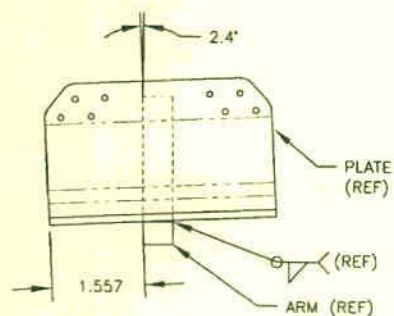




D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

**GENERAL NOTES**

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.22  
**UNDER REVIEW**  
07.10.22 DC

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

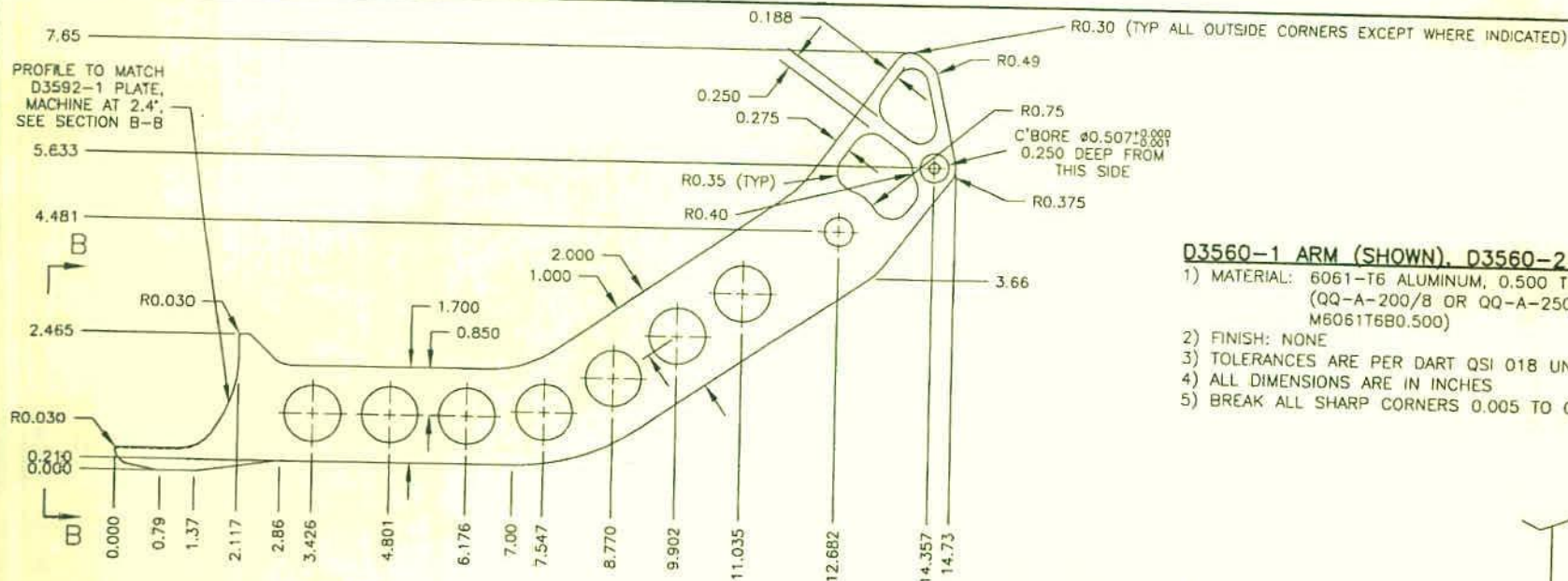
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	qj	DRAWN BY qj
CHECKED	qj	APPROVED qj
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. WILMINGTON, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 1 OF 3
		SCALE 1:4

*W035247*

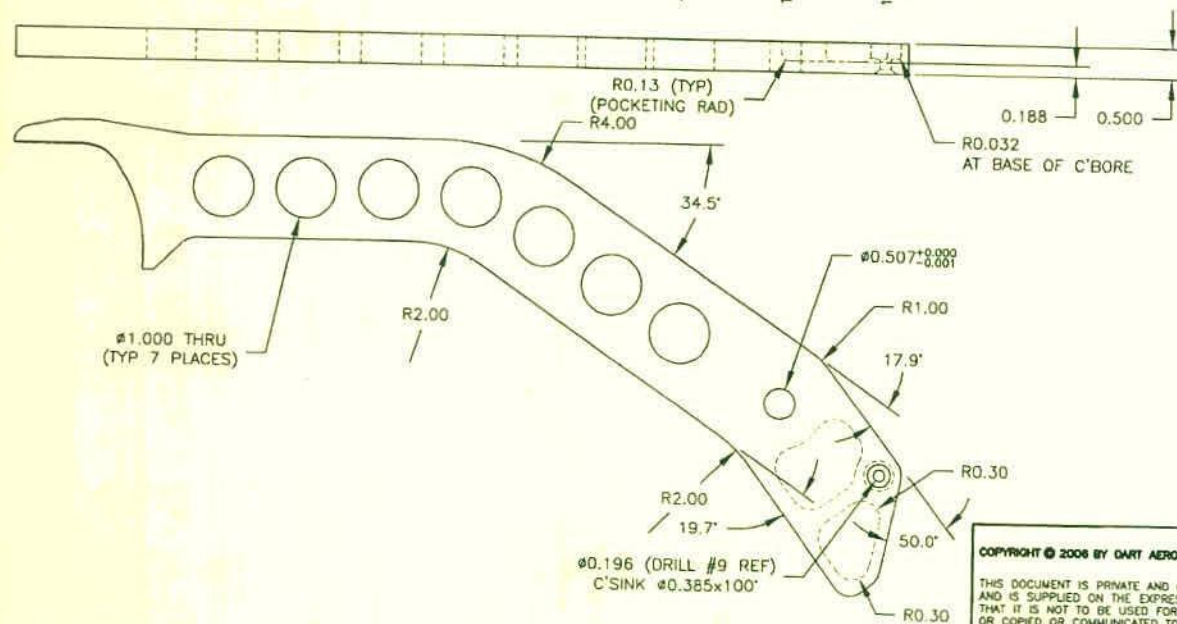






# **D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (QQ-A-200/B OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



**SECTION B-B**  
SCALE 1:1

**RELEASED**  
07.06.19

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	QD	DRAWN BY	QD	<b>DART</b>	DART AEROSPACE LTD.
CHECKED	CH	APPROVED	CH	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 2 OF 3
				SCALE	1:2

